

Date: Thursday, 3/20/2008 9:54:25 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TURNING DETAIL FOR D2896-1
Job Number	: 38133		
Estimate Number	: 13236		
P.O. Number	:	Part Number	: DSK080
This Issue	: 3/20/2008 S.O. No. :	Drawing Number	: DSK080 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 4/3/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>08 03 20</u>		
Comment	: est rev A. 08.03.13 new issue EC		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6104011

17-4 SS Roundbar 6.50"OD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Billet

Batch: 3 3557720 08/04/02

2.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE  
 Turn blank as per Folio FA167

20 08/04/02

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/04/02

(10)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

20 08/04/07

(10)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 Identify and Stock in Kanban  
 Location: CNC

20 08/04/07

(10)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/09

Job Completion

Wmf 08-04-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

38133

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <u>35577</u>
<b>Description:</b> Support		<b>Part Number:</b> D2896-1
<b>Inspection Dwg:</b> D2896 Rev. B		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2896 Rev B/DSK080 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
<b>Lathe Section</b>									
A	3.480	3.485		3.484	3.484	3.485	3.485		
B	3.990	4.010		3.995	3.995	3.997	3.995		
C	3.825	3.845		3.835	3.835	3.835	3.835		
D	0.718	0.738		0.728	0.728	0.728	0.728		
E	0.090	0.110		0.100	0.100	0.100	0.100		
F	3.705	3.725		3.715	3.715	3.715	3.715		
G	1.360	1.380		1.372	1.372	1.372	1.372		
H	1.250	1.260		1.255	1.255	1.255	1.255		
I	6.490	6.510		6.490	6.497	6.497	6.497		
J	0.022	0.042		0.032	0.032	0.032	0.032		
K	0.240	0.260		0.250	0.250	0.250	0.250		
L	0.107	0.127		0.117	0.117	0.117	0.117		
M									
<b>HAAS Section</b>									
AA	2.152	2.172							
AB	2.340	2.360							
AC	3.550	3.560							
AD	3.770	3.790							
AE	0.065 x 0.315	0.085 x 0.335							
AF	1.42	1.48							
AG	0.833	0.853							
AH	0.240	0.260							
AI	0.261	0.266							
AJ	0.189	0.194							
AK	1.990	2.010							
AL	0.625	0.630							
AM	101.75	105.75							
AN	0.053	0.073							
AO	0.926	0.946							
<b>Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"</b>									
<b>Accept/Reject</b>									

Measured by: <u>RG</u>	Audited by: <u>S.F</u>
Date: <u>08/17/07</u>	Date: <u>08/29/07</u>

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	

38133

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	35571
<b>Description:</b> Support	<b>Part Number:</b>	D2896-1
<b>Inspection Dwg:</b> D2896 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2896 Rev B/DSK080 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
<b>Lathe Section</b>									
A	3.480	3.485		3.484	3.484	3.485	3.485		
B	3.990	4.010		3.995	3.995	3.997	3.995		
C	3.825	3.845		3.835	3.835	3.835	3.835		
D	0.718	0.738		.725	.728	.728	.728		
E	0.090	0.110		.100	.100	.100	.100		
F	3.705	3.725		3.715	3.715	3.715	3.715		
G	1.360	1.380		1.372	1.372	1.372	1.372		
H	1.250	1.260		1.255	1.255	1.255	1.255		
I	6.490	6.510		6.500	6.497	6.497	6.497		
J	0.022	0.042		.032	.032	.032	.032		
K	0.240	0.260		.250	.250	.250	.250		
L	0.107	0.127		.117	.117	.117	.117		
M									
<b>HAAS Section</b>									
AA	2.152	2.172							
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AO	0.926	0.946							
<b>Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"</b>									
<b>Accept/Reject</b>									

Measured by:	RGP
Date:	08/04/07

Audited by:	RF
Date:	08/04/07

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
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38133

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 35577
<b>Description:</b> Support	<b>Part Number:</b> D2896-1
<b>Inspection Dwg:</b> D2896 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2896 Rev B/DSK080 Rev A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
<b>Lathe Section</b>									
A	3.480	3.485		3.484	3.484	3.485	3.485		
B	3.990	4.010		3.995	3.995	3.997	3.998		
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D	0.718	0.738		0.725	0.728	0.725	0.728		
E	0.090	0.110		0.100	0.100	0.100	0.100		
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AJ	0.189	0.194							
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AL	0.625	0.630							
AM	101.75	105.75							
AN	0.053	0.073							
AO	0.926	0.946							
<b>Ensure that Ø0.625" bore is perpendicular to 1.764" bore within 0.005"</b>									
<b>Accept/Reject</b>									

Measured by: 729
Date: 08/04/07

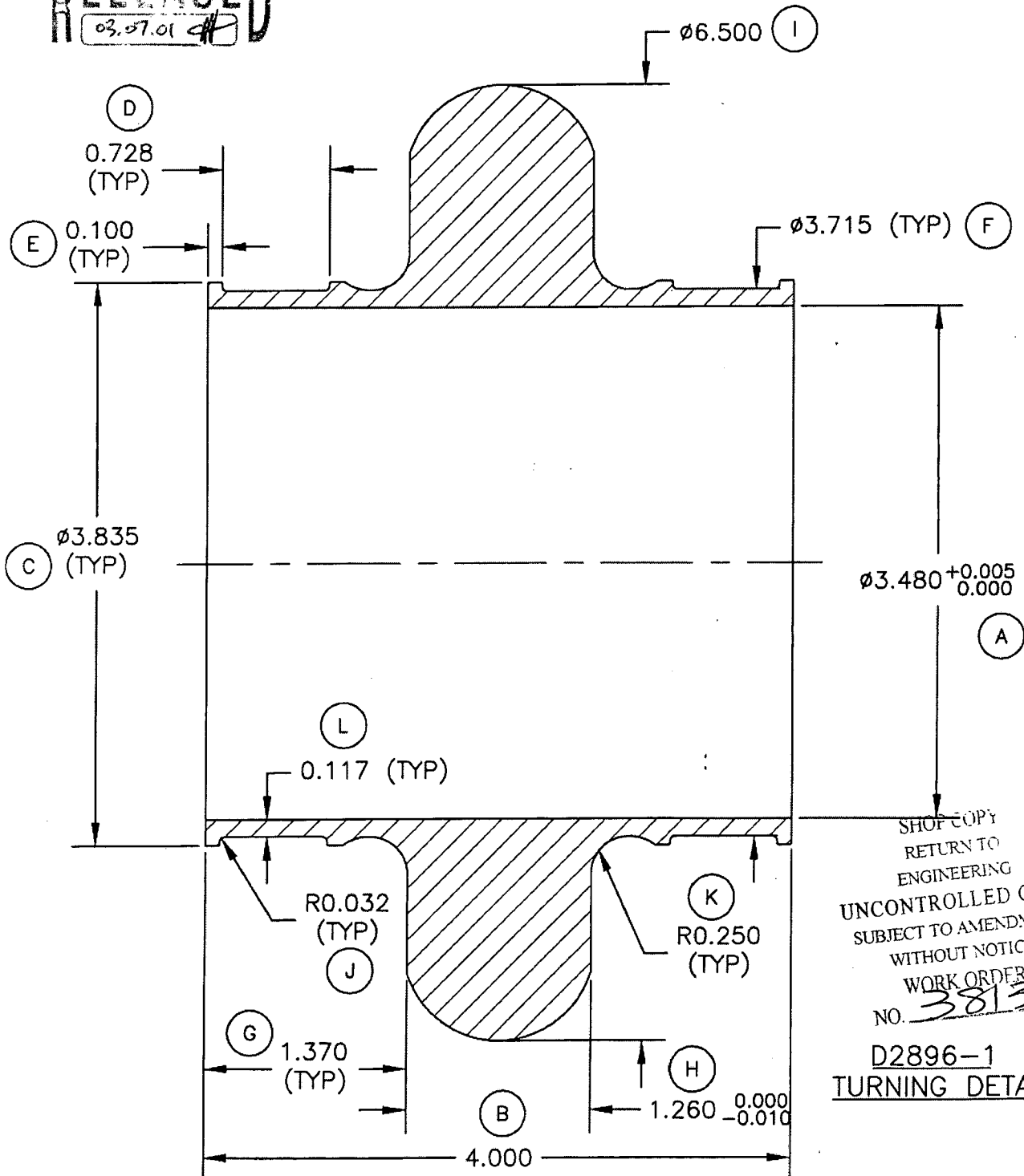
Audited by: 2.5
Date: 08/04/07

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	04.05.27	Dimension AE changed	KJ/RF	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	07.04.16	Dimsheet updated per Dwg Rev. B	KJ/JLM	



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSK 080	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2896-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED  
03.07.01



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38133  
D2896-1  
TURNING DETAIL

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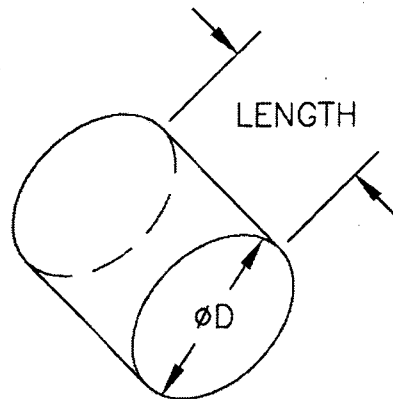


DESIGN E4	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D6104	Rev. B SHEET 1 OF 1
DATE 02.11.25		TITLE ROUND BILLET, 17-4 SCALE NTS	
A	01.04.10	NEW ISSUE	
B	02.11.25	CLARIFY ALLOY SPEC ADDED D6104-009/-011 REDUCE LENGTH OF BILLETS	

RELEASED

02.11.25

## SPECIFICATION CONTROL DRAWING



MATERIAL: 17-4 PH SS (AMS 5643 OR AISI 630) MIN UTS = 170 KSI (38 HRc)

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES

Part No.	Alloy	D (Diameter)	Length
D6104-001	17-4 PH STAINLESS STEEL	Ø3.00	3.80
D6104-003	17-4 PH STAINLESS STEEL	Ø3.25	3.80
D6104-005	17-4 PH STAINLESS STEEL	Ø4.00	5.10
D6104-007	17-4 PH STAINLESS STEEL	Ø4.50	5.10
D6104-009	17-4 PH STAINLESS STEEL	Ø5.25	4.10
D6104-011	17-4 PH STAINLESS STEEL	Ø6.50	4.10

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